

Date: Monday, 9/11/2006 3:41:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING BRACKET
 Job Number : 28470
 Estimate Number : 12473
 P.O. Number : N/A Part Number : D3246041
 This Issue : 9/11/2006 S.O. No. : N/A Drawing Number : D3246 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A1
 Previous Run : 27670 Material : N/A
 Due Date : 9/18/2006 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-06-22 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S050

2024-T3 .050 sheet



Comment: Qty.: 0.3252 sf(s)/Unit Total: 1.3007 sf(s)

2024-T3 .050 sheet

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050)

Identify for D3246-1

Batch: 11905311/06/09 14

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg Dsi9279

Dwg Rev: A1Prog Rev: AL

2-Deburr if necessary

11/06/09 14

(4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

11/06/09 14

(4)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06-09-16 (4)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D3246

C'sink as per Dwg D3246

SB 06/11/09 (4)
FF 06-11-09 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:41:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 28470

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NOV 06/11/09 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4th 06/11/10 x 4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06-11-14

9.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

Pick:

Qty Part Number Description Batch

8 MS20426AD3-3 Rivet

1719099

FF 06-11-14

10.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

4 MS21059L3 Nut Plate

1719393

Identify as D3246-041

FF 06-11-14

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/09

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)

06/11/16

Job Completion



10.1 INSTALL NUT PLATES AS PER Dwg D3246.

FF 06-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
26/11/15	1/b	add ID + sth (pkg) permanent change	pu	6/11/15	4	u	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/11/15

QA: N/C Closed: _____ Date: _____

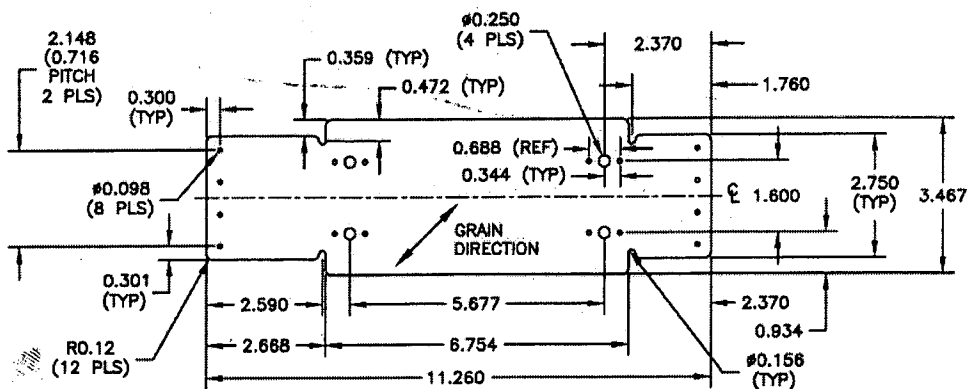
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

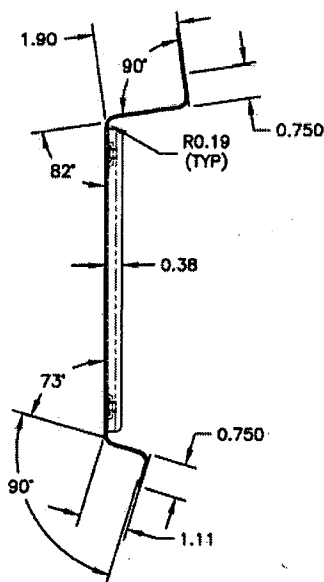


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21	TITLE MOUNTING BRACKET		SCALE 1:4
A	04.04.21	NEW ISSUE	
A1	04.06.16	CHANGE RIVET; ADDED C'SINK	

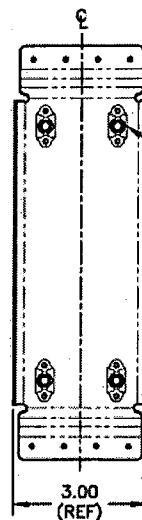
RELEASED
04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK $\phi 0.135 \times 100^\circ$
MS20426AD3-3 RIVET (2)



D3246-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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